

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000332**Date Inspected:** 31-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	RT Review & WQT	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger observed welder qualification testing (WQT) by Moody International Inspectors Feng Lin Yao, Tang Li Pang, Certified Welding Inspector Zhou Daqing and He Jia Min at ZPMC today. There were no ZPMC Certified Welding Inspectors today however there were four assistants and one American Bridge/Fluor employees Mr. Danny Mc Donald. There were a total of 35 welders which attempted welder qualification test for yesterday in the shield metal arc (SMAW), submerged arc (SAW) and the flux cored arc (FCAW) welding process. There were of total of 18 FCAW welder tests attempted with 11 passing final visual inspection, and a total of 12 SMAW tests attempted with 7 passing final visual inspection and a total of 5 SAW tests attempted with 1 passing final visual inspection. Moody International Certified Welding Inspector Zhou Daqing performed the final visual inspections. The Moody International, ZPMC and ABF inspectors were observed checking the welding parameters for the welders being tested. A random inspection was made of the various volt/amp gauges and temperature gauges for calibration of which all were found to be in a current state of calibration.

This Caltrans QA Inspector Bruce J. Berger reviewed the radiographic film for 6 procedure qualification test plates.

The PQR plates for which film was reviewed were HP2007144-1; HP2007147; HP2007148; HP2007149; HP2007153 and HP2007249-2. All film and welds appeared to be in compliance with the code and specification. For details see Weld Witness Reports TL-6032s dated July 31, 2007

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Summary of Conversations:

No relevant conversations took place on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: McClary, David

QA Reviewer
